Work Order ID 70422

Tuesday, June 07, 2011 1:41:21 PM

Item ID: D4038-11 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Block

Start Date: 6/7/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 6/21/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/06/07 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4038 / E									
100		0.00							
Bandsaw	**Memo**	0.00	~~RO~~ 11/06/08			10			
Jeaspa Bandsaw	CUT BLANK 2.00" LONG								
105		0.00							
HAAS 1 Reich	**Memo**	0.00				CL 11/06/09	10		
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA886 DWG REV: _____ FOLIO REV: _____ DEBURR								

issue P/O: 142260

Dan's Precision machine as per dwg D4038 REV. E

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 rec'd QC Quality Control	QC2- Inspect parts off ~~machine FAI/FAIB~~	0.00				10	0	12 (1)	
	Memo	0.00							
	rec'd + inspect ~~as per above~~ for transit damage attached coc to WO								
120 QC Quality Control	QC2- Inspect parts - second check	0.00							
	Memo	0.00							
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				10		11-7-11	
	Memo	0.00							

Ato →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D4038 -11 **PAR #:** N/A **Fault Category:** ~~Machining~~ Supplier **NCR:** (Yes) ~~No~~ **DQA:** ~~See NCR~~ N/A **Date:** 11.07.06

11-697 **Resolution:** Scrap **Disposition:** Scrap **QA: N/C Closed:** CK **Date:** 11/07/06

NCR: 70422		WORK ORDER NON-CONFORMANCE (NCR) $ 33.92						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
11/6/30	# 110	When Supplier was machining D4038-11 it was found that OAL +1 Blank was cut too short. R.C. emply never measured	11.07.06	Scrap + Destroy. extra's were sent. See Attached Emails	SCRAPPED BY SUPPLIER		11.07.06	11/06/30
		Blanks after cutting LOA						

NOTE: Date & initial all entries

Work Order ID 70422

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Revision ID:

Item Name: Block

Start Date: 6/7/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 6/21/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				10	0		ML 11/07/04
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: 115	0.00							11/7/4 SL
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							11/7/4
QC	**Memo**	0.00							CL 11/07/04
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 1:41:18 PM

Work Order ID: 70422

Parent Item: D4038-11

Parent Item Name: Block

Start Date: 6/7/2011 **Required Date:** 6/21/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.000		Purchased	No				f	24.7077		1.747368			

6061-T6 Bar 1.50 x 2.00

Location	Loc Qty	Loc Code
MAT010	24.70768	
110167	0.65	
114608	4.05768	
117933	20	

1.9 f #0 11/06/08

D4038-11P

12/4/27 (10)

Dart Aerospace Ltd

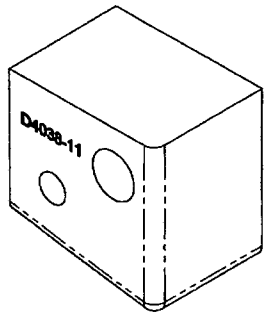
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

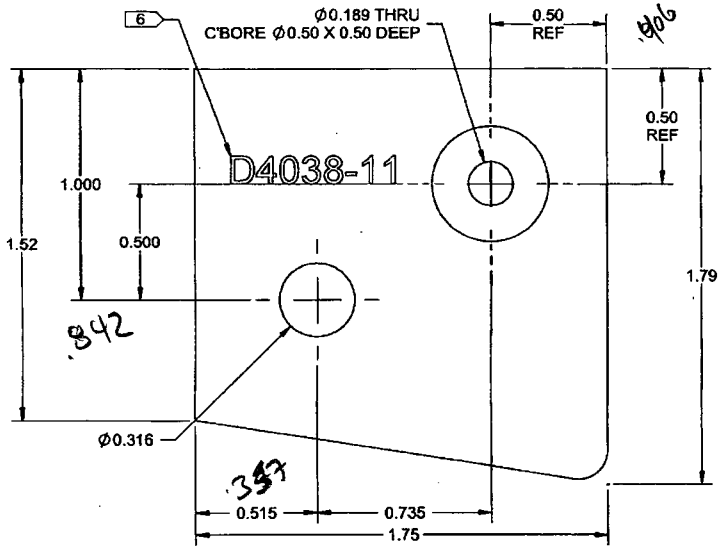
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

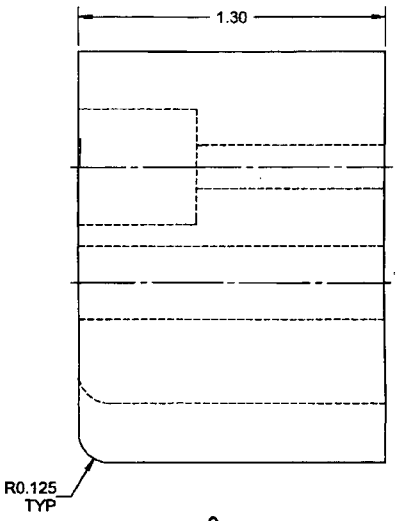
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







CL11106107

W10: 70422

RELEASED
2011-04-20

D4038-11 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4038 REV. E
MFG. APPR.		SHEET 13 OF 14
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 11.04.11		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.
2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifations.

Date : 27-Jun-11
Purchase Order : PO14260 δ u/o 6/30
Packing Slip : 10529
Part Number : D4038-11revE
Quantity : 10

Per: _____
For Dan's Precision Tools Inc.

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: June 27, 2011 12:54 PM
To: JEANLUC MENARD; khaled@dans-precision-tools.com
Cc: 'Chantal Lavoie'
Subject: RE: PO14260
Attachments: PO14260.pdf

Hi all,
Line 1,2 & 3 can be short shipped, no problem. Attached is the revised PO, let me know if we got it right. As for the 1 blank scrap, can we remove it from the price of the item?
Thx
Linda Lacelle
Production Manager
Dart Aerospace

From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: June 27, 2011 12:44 PM
To: L Lacelle
Subject: FW: PO14260

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: June 27, 2011 12:17 PM
To: DART - Jean-Luc Menard
Subject: PO14260

Bonjour Jean-Luc,

We'll have 14 to 15 lines on this PO delivered this afternoon. Driver will be leaving here around 1:30.

I have, however, a couple of issues I'd like to bring to your attention:

1. D4038-11: One blank was cut short, but we ran 10 pieces accidentally using a D4038-9 blank. Result = we're short 1 piece of D4038-9.
2. D4038-7: Short 1 piece. We ran it as D4038-6.
3. D4078-1: Short 1 piece. We scrapped it during production.
4. You have supplied and we ran 11 pieces of 3573-1 and 3573-8. PO calls for 10 of each. If 11 is what you require please amend PO to match. If not I will send them to you as spares.

Could you please advise as to whether we could ship short for 1,2 and 3 above or if you'd like us to pick up replacement material for more parts?

Give a call when you have a moment. I need to talk to you regarding specs for Rack and Pinion as well

Thank you,
Khaled

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: June 28, 2011 7:23 AM
To: 'Khaled - Dan's Precision Tools'; 'JEANLUC MENARD'
Cc: 'Chantal Lavoie'
Subject: RE: PO14260

Hi again Khaled,
I just checked the cost of the blank, it's not worth enough to deduct the cost for the scrap piece, so forget about it...
Thanks for your fast delievry!

Linda

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: June 27, 2011 3:15 PM
To: Linda Lacelle; JEANLUC MENARD
Cc: 'Chantal Lavoie'
Subject: Re: PO14260

Good afternoon,

Thank you for the updated PO. Everything is correct.

I must admit though that I'm not sure I understand your question. But if it is about subtracting material cost of scrapped piece of D4078-1 from price, you certainly can. If not please advise.

Thank you,
Khaled

----- Original Message -----
From: Linda Lacelle
To: JEANLUC MENARD ; khaled@dans-precision-tools.com
Cc: 'Chantal Lavoie'
Sent: Monday, June 27, 2011 12:53 PM
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